

Date: Monday, 1/14/2008 2:37:35 PM
 By: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR WEDGE		
Job Number	: 36753		Part Number	: D32001		
Estimate Number	: 12110		Drawing Number	: D3200 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 1/14/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type :	Due Date	: 2/5/2008	Qty:	40
Previous Run	: 32472		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev A Removed from 9 Digit 06-01-25 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MUHMWB10	UHMW 1" Black J.L 08/02/06 40
Comment: Qty.: 0.0525 sf(s)/Unit Total : 2.1000 sf(s) UHMW 1" Black Material: Black UHMW 0.95" or 1.00" thick Use bearpaw scrap material (MUHMWB10) Identify for D3200-1 Batch: <u>M106161</u>		
2.0	BAND SAW	BAND SAW J.L 08/02/06 40
Comment: BAND SAW Cut blank: 2.700" x 2.700		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 J.L 08/02/06 40
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3200-1 as per Folio FA337 and Dwg D3200 2-Deburr		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE J.L / J.L 08/02/07 40
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36753		Part Number: D32001
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		<i>SG 08-02-07 10</i>
6.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>76</u>		<i>8/2/8 SC 40x</i>
7.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>D 08/02/08</i>
Job Completion 		<i>min 2008/2/08 40 W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36753
Description: Door Post Block	Part Number:	D3200-1
Inspection Dwg: D3200	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JL	Audited by:	ZG	Prototype Approval:	N/A
Date:	08/02/06	Date:	08/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	P/O D412-698-015	KJ/RF <i>OK</i> <i>PP</i>

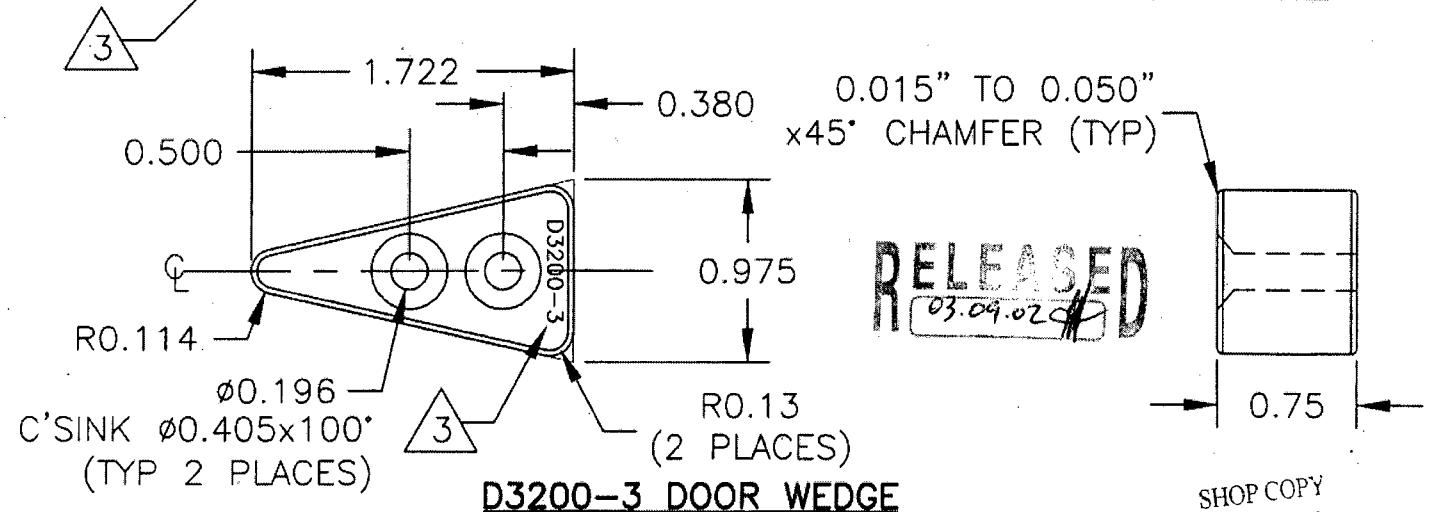
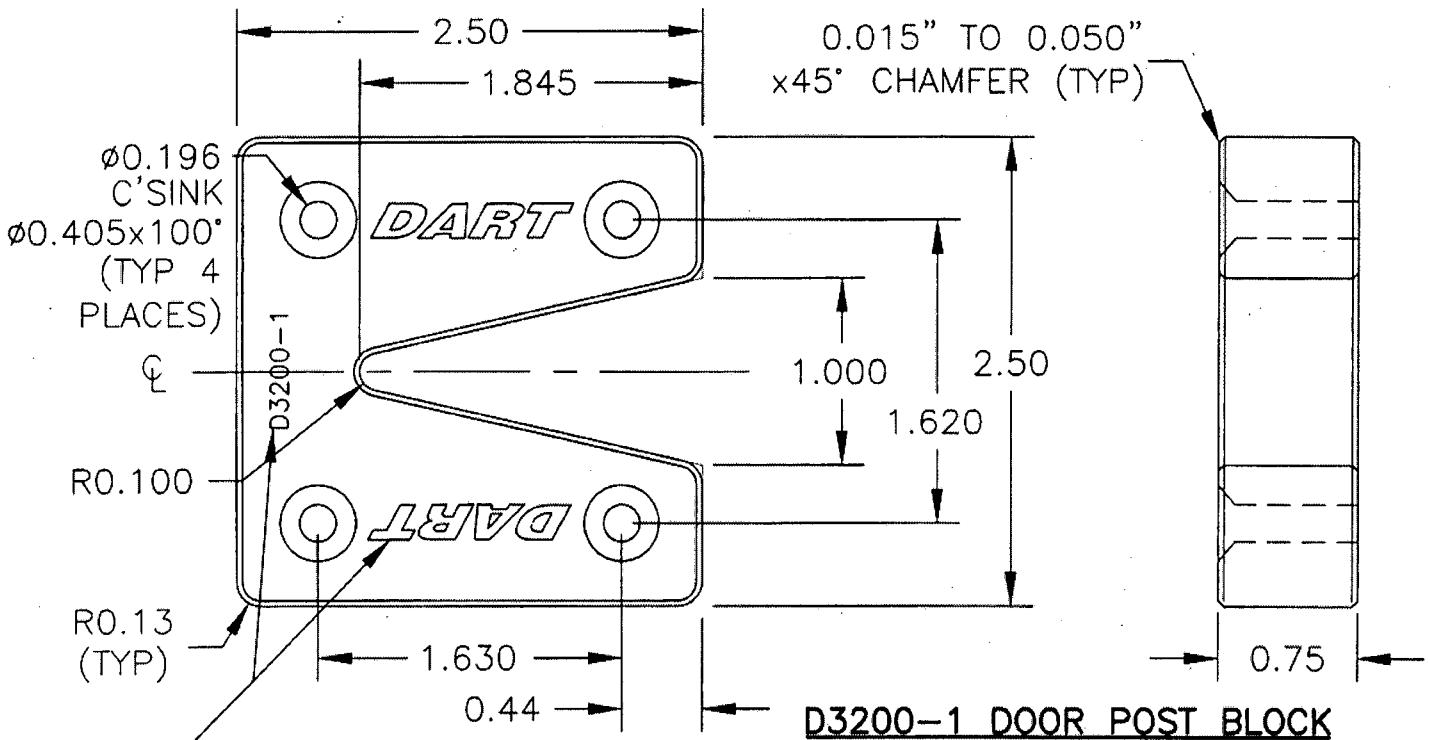
4



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3200
DATE		TITLE DOOR WEDGE
03.08.06		SCALE 1:1

REV. A
SHEET 1 OF 1

A 03.08.06 NEW ISSUE



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36753

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